

SHIP 02/05

Dart Aerospace Ltd.

Date: Thursday, 4/12/2007 8:51:58 AM  
User: Kim Johnston

## Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LH STEP ACTUATOR ASSEMBLY  
Job Number : 31744  
Estimate Number : 12760  
P.O. Number :  
This Issue : 4/12/2007 S.O. No. :  
Prsht Rev. : NC Part Number : 41232 000 001 002  
First Issue : / / Type : SMALL /MED FAB Drawing Number : 41232-000-001 REV A  
Previous Run : 31568 Drawing Revision : A  
Material :  
Due Date : 5/10/2007 Qty: 4 Um: Each  
Written By :  
Checked & Approved By : 07.04.12  
Comment : Est Rev:A New Issue 07-02-28 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP41232-000-001

CHG 001 002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 AP0925ELBN BARBED ELBOW



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

BARBED ELBOW

Batch: M103727 ✓ ✓

4.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M102929 ✓ ✓

5.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M103914 ✓ ✓

7/5/4 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 4/12/2007 8:51:58 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH STEP ACTUATOR ASSEMBLY

Job Number: 31744

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN423A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M103688 ✓

M14067 ✓

7.0

MS3548993

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GROMMET

Batch:

M103688 ✓

8.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch:

M103962 ✓

9.0

MS24665151

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cotter Pin

Batch:

M14526 ✓

10.0

MS203923C21

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pin

Batch:

2\* 52 in the stock

M11765 ✓

11.0

R 3400

plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total : 12.2000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch:

M103351 ✓ M104229 ✓

12.0

41232 200 006 001

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

Batch:

B30505 ✓

7/8/13 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH STEP ACTUATOR ASSEMBLY

Job Number: 31744

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

41232 200 005 001

Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Spacer (Step Actuator)

Batch: B30503 ✓ ✓

14.0

41232 200 004 001

Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Reducer Tee Assembly

Batch: B30502 ✓ B31018 ✓ 31779 ✓

15.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring (Step Actuator)

Batch: N/A ✓ 4170507 ✓

16.0

41232 200 001 002

Step Actuator RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Step Actuator RH

Batch: B31745 ✓ 1X ✓

17.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring (Step Actuator)

BATCH: B30501 ✓ B30940 ✓ 7/5/13 50 (4)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Rev 7/5/13 50 (1)

add to kit 1 case 124K002 40K 6545  
was part of assy w/o - should be on pick up

m 104389

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH STEP ACTUATOR ASSEMBLY

Job Number: 31744

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

200

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 0705.15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries













Thursday, 4/12/2007 8:52:30 AM  
Kim Johnston

## Process Sheet

Split  
8/07/05/11

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 31745  
Estimate Number : 12761  
P.O. Number : N/A  
This Issue : 4/12/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL / MED FAB  
Previous Run : 31450  
Drawing Name : LH ACTUATOR ASSEMBLY  
Part Number : 41232 200 001 001  
Drawing Number : 41232-200-001 REV IR  
Project Number : N/A  
Drawing Revision : IR  
Material : N/A  
Due Date : 5/10/2007 Qty: 4 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est Rev: A New Issue 07-02-28 JLM

## Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

MS208224

elbow

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

elbow

Batch: M103688

2.0

124K002 4CR 0545

Hose ass'y-Step Actuator

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose ass'y-Step Actuator

BATCH:

07/05/11

3.0

AN8424D

Elbow

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Elbow

Batch: M104156

4.0

41232 200 007 001

Brass Cylinder Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Brass Cylinder Assembly

Batch: B30542

5.0

MS1699623

cap screw

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

cap screw

Batch: M103934

8/07/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/11	16	Split w/o	SB	07/05/11	1		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



Thursday, 4/12/2007 8:52:30 AM

Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31745

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M 17566

7.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M 102929

8.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M 100743

9.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M 104215

10.0

AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M 3413

11.0

41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer (Step Actuator)

Batch: B 31022

12.0

41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pivot arm

Batch: B 31021

SB 02/05/11 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	SB	<u>Qty</u> 1	<u>Part #</u> 51455	<u>desc.</u> spring	<u>batch</u> 4104079	EE	07-05-11	1		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



Thursday, 4/12/2007 8:52:30 AM

Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31745

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

latch

Batch: B31277

14.0

41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

tube

Batch: B31019

15.0

41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Decal

Batch: H31023

SB 07/05/11 (1)

16.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

SB 07/05/11 (1)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07-05-11 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 7/5/11 (1)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/05/11 (1)  
W 8/10/11

Job Completion





# Dart Aerospace Ltd

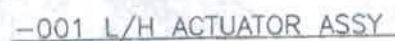
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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⚠ TORQUE 80-100 IN.-LB.  
⚠ TORQUE 20-25 IN.-LB.  
⚠ TORQUE 50-75 IN.-LB.  
⚠ TORQUE 50-75 IN.-LB.

NOTES:

INSTALL ITEM #12  
ON OPPOSITE SIDE

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 31745

[illegible]

